



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-4-4KA
Job Sheet 172185



Part No: C45-4-4KA

Job Qty: 8-ea **3**

Part Name: Load Beam Keeperless Assembly



5090059

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 2/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-4-4KA rev.20 IPP REV:A 18.02.09 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		2/17/18	0.00	0.00	Start Up Small Fab-4		SB
100	Small Fab	8 pcs		2/19/18	0.08	0.53	Small Fab-9		DAS
110	QC	8 pcs		2/19/18	0.00	0.00	QC5		38
130	Outsource	8 pcs		2/19/18	0.00	0.00	Outsource15		CC18-9
140	Packaging	8 pcs		2/19/18	0.00	0.00	Packaging2		CC18-07-13
150	QC	8 pcs		2/19/18	0.00	0.00	QC6		38
160	Packaging	8 pcs		2/19/18	0.00	0.00	Packaging3-2		5018-8-1
170	QC21-FG	8 Ea		2/19/18	0.00	0.00	QC21		21

Part Op 100 - ASSEMBLE AS PER DWG

Descriptions: 130 - Issue P/O to Groupe Altech: P/O **040433** -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel
Plate .0009-.0011 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-4-2	Trunnion, Load Beam	8 Ea (1 ea)	90-Start up Operation	5089856
C45-4-4K	C45 Load Beam Keeperless	8 Ea (1 ea)	90-Start up Operation	5046925

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C45-4-2	8	0	0
	C45-4-4K	8	0	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

☐ Work Order update only

AGAINST DEPARTMENT/PROCESS			
Engineering	Water Jet	Cross tube	Skid-tube
Quality	Prod. Eng. Coord.	Small Fab	Machining
Other	Rec/Store/Packaging	Finishing	Th
	Supplier	Composite	

DISPOSITION	
Rework	Suspected Unapproved
Scrap	
Use-as-is	

Work Order:	
Part No.	NCR No.

Description Work Order Deviation	
Date :	Step #:

Completed By	
MRB (QS1042) Approval	

Lead hand / Supervisor	
Approval Verification	

QC / QA Coordinator	
Approval	

Root Cause	
Environment	Design
Doc/Data	Equip/Tooling
Handling/Pre	Material
Internal Transport	Tribal Knowledge
LOA	Substation
Past Expiry Date	Misidentified

Root Cause	
No Re-verification	Operator
Offset/Setur	Supplier
Traini	Use for
Poor Informa	Rushing
Product Improvement	Process Improvement
Manufacturing Process	Past Due
OTHER :	

Root Cause	
Positioned Wrong	Outside Dimensions
Over/Under tolerance	Part Incorrect
Part Lost/Missing	Part Moved
Drawing	Finish
Misread	Turning Sequence

Root Cause	
Power Loss/Surge	Folio/Program
Weld	Grain
Wrong Stock Pulled	Out of Sequence
Off-set	Mislabeled
Fit/Function	Misaligned/off center

Root Cause	
Unclear	

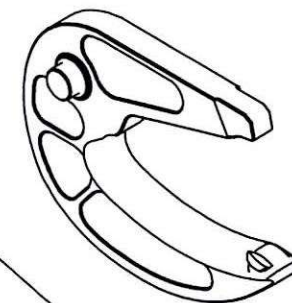
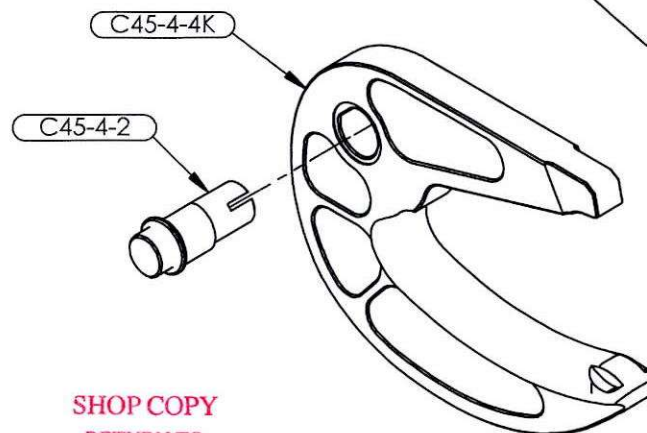
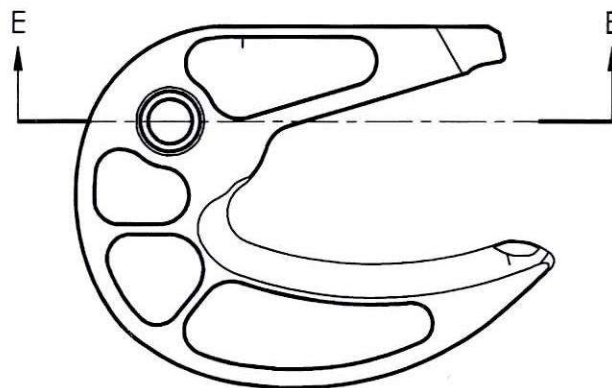
DART
AEROSPACE
Container No: S090059
Part: C45-4-4KA
Job No: 172185
Serial No/Batch: S090059
Revision: 20
Inspector:
Exp Date:
Instructions:

Date: 07/12/18

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev 1
Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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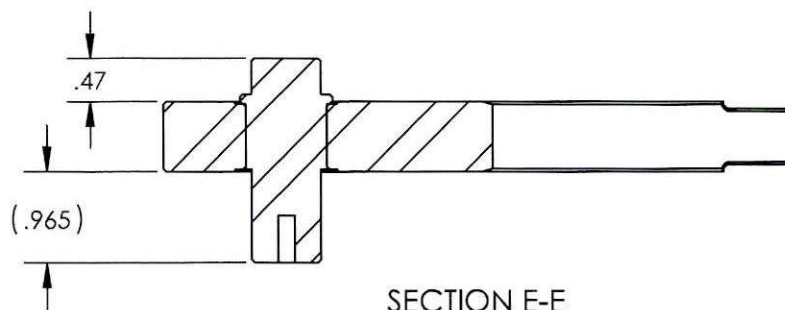
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
19	15-0099	C45-4-4KA ADDED TO DRAWING FOR KEEPERLESS OPTION.			5/8/2015	RJC JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172185 MWS
1802-13

NOTE:
1. NICKEL PLATE .0009 - .0011, BAKE AFTER PLATING.



SECTION E-E
SCALE 1 : 2

C45-4-4KA

C45 LOAD BEAM KEEPERLESS ASSY.

DART AEROSPACE	
TITLE C45 LOAD BEAM ASSEMBLIES	
DWG NO. C45-4-4A / C45-4-4KA	REV 20
MAT'L HEAT TREAT FINISH SEE NOTE 1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/05/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/14/2017	USED ON MODEL
APPROVED: JAG 06/15/2017	
SCALE 1:3	DATE 5/7/2015 SHEET 5 OF 6



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040433**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040433
PO Date: 7/9/18
Due Date: 7/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172185	C45-4-4KA	Load Beam Keeperless Assembly -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required	Firmed	-	7/16/18	3 pcs	0 pcs	3 pcs	\$16.60/pcs	\$49.80
2	174416	C45-4-4A	C45 Load Beam Assembly -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required	Firmed	-	7/16/18	4 pcs	0 pcs	4 pcs	\$17.55/pcs	\$70.20
Grand Total:											\$120.00

Order Notes

CE



Certificat de Conformité / Certificate of Compliance

(010881-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010881 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Jul-2018		Aman		040433				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C45-4-4KA Rev.	C45-4-4KA NICKLE PLATE, QQ-N-290 CLASS 2, GRADE C NICKLE PLATE .0009-.0011 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200]	E-NICKEL ALUM CH	3	3	0	0	0
2	C45-4-4A Rev.	C45-4-4A NICKLE PLATE, QQ-N-290 CLASS 2, GRADE C NICKLE PLATE .0009-.0011 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200]	E-NICKEL ALUM CH	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.